



The Expert in Fibre Reinforced Pipe Systems

## Bolt Torques Tightening Procedure

### GRE and GRV Pipe and Fitting

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- 1.1 GRP collar / steel loose flange ( backing ring )
- 1.2 GRP collar / GRP loose flange or fix flange against not full-face area
- 1.3 GRP fix flange against full-face area and with full-face gasket
- 1.4 Increase the bolt torque in steps of 15 Nm; bolts to be screwed

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**1.1 GRP collar / steel loose flange ( backing ring )**

Against not full-face area

Gasket: Kroll u. Ziller

G-ST Profildichtung

DN	Bolt torque in Nm
25 - 80	25
100 - 150	50
200 - 250	75
300 - 400	100
500 - 600	200
700 - 900	300
1000 - 1400	500

**1.2 GRP collar / GRP loose flange or fix flange against not full-face area**

Gasket: Kroll u. Ziller

G-St profile

DN	Bolt torque in Nm
25 - 50	17
65 - 100	25
125 - 150	30
200 - 300	50
350 - 400	75
500 - 600	90
700 - 900	100
1000 - 1400	150

**1.3 GRP fix flange against full-face area and with full-face gasket**

DN	Bolt torque in Nm
25 - 80	25
100 - 150	50
200 - 250	75
300 - 400	100
500 - 600	200
700 - 900	300
1000 - 1400	500

**1.4 Increase the bolt torque in steps of 15 Nm; bolts to be screwed  
Increase of torque increments of 100 Nm from nominal diameter of DN500**

